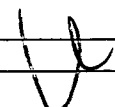
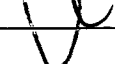


Date: Thursday, 07/12/2006 12:31:11 PM
 User: Linda Lacelle

Process Sheet

Customer : CC-DAR01 Dart Aerospace Ltd.	Drawing Name : K10007
Job Number : 29842	
Estimate Number : 10804	
P.O. Number : N/A	Part Number : K10007
This Issue : 07/12/2006 S.O. No. : N/A	Drawing Number : RTN544
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : MACHINED PARTS	Drawing Revision : N/A
Previous Run : 00015	Material : N/A
Written By : 	Due Date : 14/12/2006 Qty: 1 Um: Each
Checked & Approved By : 	
Comment :	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	QC5	INSPECT WORK TO CURRENT STEP
-----	-----	------------------------------



Job 12-07 ①



Comment: INSPECT RTN544

2.0	K10007	Bearpaw Kit 19" x 16"
-----	--------	-----------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
 Bearpaw Kit 19" x 16"
 ORIGINAL B/N 22492

12/4/08 ①

3.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1
 REPACKAGE PER PPP
 USING NEW B/N
 NEW LABELS & PAPERWORK REQ'D

new E

chg003

12/4/08 ①

4.0	QC21	FINAL INSPECTION/W/O RELEASE
-----	------	------------------------------



Comment: FINAL INSPECTION/W/O RELEASE

12/12/13 ①

Job Completion



12/12/13

5/15

DART AEROSPACE LTD	Work Order:	22492
Description: Bearpaw Kit (19" x 16")	Part Number:	K10007
Dwg: D2435 Rev. E1; DSK086-3 Rev. A	Qty:	20
Page 1 of 1		

Step	Location	Procedure	By	Date	Qty																																																
1	DC	Issue Traveler Note: (1) K10007 Kit consists of Qty (2) D2435 Dwg not required	HA	05.02.21	20																																																
2	DC	Photocopy bluefile: K10007 D206-559 D500-572 D120-638 D058-678 and create labels per PPP K10007 CHG003 (Bag Bluefiles separately)	UK13 HA DH	05.04.05	20																																																
3	GA	Cut 2 blanks per K10007 Kit Cut blank: 16.00" x 19.50" x 1.00" thick (+0.030/-0.000) per DSK086-3 Material: Black UHMW 1" (MUHMBW10) Batch: <u>M15926</u>	gml	05/03/09	20																																																
4	MV	Inspect material for defects or damage prior to machining	gml	05/03/09	20																																																
5	MV	Machine as per Folio D2435 and Dwg D2435 Identify as D2435	EP	05/03/10	20																																																
6	QC2	Inspect parts as they come of the CNC machine	EP	05/03/10	20																																																
7	MV	Deburr	EP	05/03/11	20																																																
8	QC8 & 5	Second inspection	PL	05.03.28	20																																																
9	KP	Pick: Packing Kit (Note: D2435 is not on the BOM, but is in as material from step 3) <table><thead><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr></thead><tbody><tr><td>4</td><td>D2182B050</td><td>Rubber Cushion</td><td>B21185</td></tr><tr><td>8</td><td>D2274</td><td>Radius Block</td><td>B21846</td></tr><tr><td>2</td><td>D2435</td><td>Bearpaw</td><td>B22492</td></tr><tr><td>4</td><td>D2438</td><td>Clamp</td><td>B21586</td></tr><tr><td>8</td><td>D2529</td><td>Washer</td><td>B21587A</td></tr><tr><td>8</td><td>AN4-15A</td><td>Bolt</td><td>M15321</td></tr><tr><td>8</td><td>AN4-17A</td><td>Bolt</td><td>M14526</td></tr><tr><td>16</td><td>AN960JD416</td><td>Washer</td><td>M15993</td></tr><tr><td>8</td><td>MS21042L4</td><td>Nut (or -4)</td><td>M15020</td></tr><tr><td>2</td><td>QS200M44S</td><td>Clamp</td><td>M16020</td></tr><tr><td>1</td><td colspan="3">Paperwork package from Step 2</td></tr></tbody></table>	Qty	Part Number	Description	Batch	4	D2182B050	Rubber Cushion	B21185	8	D2274	Radius Block	B21846	2	D2435	Bearpaw	B22492	4	D2438	Clamp	B21586	8	D2529	Washer	B21587A	8	AN4-15A	Bolt	M15321	8	AN4-17A	Bolt	M14526	16	AN960JD416	Washer	M15993	8	MS21042L4	Nut (or -4)	M15020	2	QS200M44S	Clamp	M16020	1	Paperwork package from Step 2			B21872 KD	05/03/31	20
Qty	Part Number	Description	Batch																																																		
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1	Paperwork package from Step 2																																																				
10	QC4	Inspect Kit for 100% Completeness on the W/O	SB	05/04/05	20																																																
11	PK	Identify and pack for shipping as per PPP K10007	REV. E CL	05/04/05	20																																																
12	AC	Cost / part <u>155.06</u>	SUR	05-04-06	20																																																
13	DC	Close W/O <u>154.59</u> Inspect Level 21	HA	05.04.12	20																																																

Rev	Date	Change	Revised By	Approved
A	99.12.17	K10007 created for Bear paw kit (MPP 2000)	EC	
B	01.03.21	Added OH-58 paperwork (MPP 2092)	EC	
C	01.11.08	Revised Step 3 and Added Level 21	SM	
D	03.03.26	Reformat; Incorporated D2435	KJ/RF	
E	04.02.17	Blank size changed, tolerance added to Step 3	KJ/JLM	

BL

RELEASED
04.07.20

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

DART AEROSPACE LTD		Work Order:	22492
Description: Bearpaw		Part Number:	D2435
Inspection Dwg: D2435	Rev: E1	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	0.063 x 45°	+0.030/-0.010	0.058x45°	✓		Vern	
B	5.500	+/-0.030	5.503	✓		Vern	
C	0.200	+/-0.030	0.201	✓		Vern	
D	R0.250	+/-0.030	R0.250	✓		Vern	
E	0.250	+/-0.010	0.256	✓		Vern	
F	0.625	+/-0.030	0.629	✓		Vern	
G	0.25 x 45°	+/-0.030	0.243x45°	✓		Vern	
H	0.375	+/-0.010	0.382	✓		Vern	
I	19.000	+/-0.030	19.000	✓		Vern	
J	0.950	+0.030/-0.010	0.967	✓		Vern	
K	Ø0.260	+0.005/-0.000	Ø0.260	✓		Vern	
L	Ø0.930	+/-0.030	Ø0.930	✓		Vern	
M	0.30	+0.030/-0.000	0.312	✓		Vern	
N	0.375	+/-0.030	0.385	✓		Vern	
O	7.375	+/-0.030	7.375	✓		M-Tape	
P	4.250	+/-0.010	4.250	✓		M-Tape	
Q	2.000	+/-0.030	2.000	✓		M-Tape	
R	9.000	+/-0.010	9.000	✓		M-Tape	
S	15.750	+/-0.030	15.750	✓		M-Tape	

Measured by:	me	Audited by:	R	Prototype Approval:	N/A
Date:	05/03/14	Date:	05.03.14	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue	P/O K10007	KJ/RF

RELEASED

04.01.15

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Feb 21, 2005
07:40 am

Work Order No : 0022492
Project Name : K10007
Project For : WK515
Work Order Type : Main
Main WO Number :
House Part Number : *K10007

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00

Description : Bearpaw Kit 19" x 16"
Manufactured : Yes
Amount Req'd : 20
Amount Done : 0
Start Date : 02-18-05
Est Finish Date : 03-30-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Order Entry No :
OE Value : 0.00
Est Margin : 0.000%
Actual Margin : 0.000%

\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	0.00	0.00	0.00	0.00	0.00
Engineering Hours	0.00	0.00	0.00		
Engineering Cost	0.00	0.00	0.00	0.00	0.00
Production Hours	0.00	0.00	0.00		
Production Cost	0.00	0.00	0.00	0.00	0.00
Packaging Hours	0.00	0.00	0.00		
Packaging Cost	0.00	0.00	0.00	0.00	0.00
OverHead Hours	0.00	0.00	0.00		
OverHead Cost	0.00	0.00	0.00	0.00	0.00
CNC Hours	0.00	0.00	0.00		
CNC	0.00	0.00	0.00	0.00	0.00
Misc. Hours	0.00	0.00	0.00		
Misc.	0.00	0.00	0.00	0.00	0.00
Burden	0.00	0.00	0.00		
Total Cost	0.00	0.00	0.00		
Margin	0.000	0.000			
Selling Cost	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00